

5/07

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	22290
<b>Description:</b> Cam Lock Shaft	<b>Part Number:</b>	D3372-5
<b>Dwg:</b> D3372 Rev. A <i>page 6</i>	<b>Qty:</b>	<i>50 25 24</i>
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>HA</i>	05.01.25	<i>50 25</i>
2	MC	Turn as per Folio FA497 and Dwg D3372 Material: AISI 303 SS Round Bar Ø0.375 (M303R.375) <b>Identify for D3372-5</b> Batch: <i>M16656</i>	<i>J.G</i>	05/10/27	25
3	QC2	Inspect parts as they come off the CNC machine	<i>J.G</i>	05/10/27	25
4	MV	Machine D3372-5 as per Folio FA497 and Dwg D3372 <b>Identify as D3372-5</b>	<i>En</i>	05/11/20	24 <i>pto</i>
5	QC2	Inspect parts as they come off the CNC machine	<i>En</i>	05/11/18	24
6	QC8	Second check	<i>En</i>	05/11/18	24
7	MV	Deburr	<i>En</i>	05/11/18	24
8	QC5	Inspect work to Step 7	<i>En</i>	05/11/18	24
9	ST	Identify and Stock	<i>CL</i>	05/11/21	24
10	AC	Cost / part	<i>J.G</i>	05-11-23	24
11	DC	Close W/O Inspect Level 21	<i>J.G</i>	05/11/23	04

Rev	Date	Change	Revised By	Approved
A	05.01.18	New issue	KJ/JLM	<i>[Signature]</i>

**RELEASED**  
*[Signature]* 05.01.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05.10.27		Update Dim. sheet E	<i>[Signature]</i>	05.11.22		<i>[Signature]</i> 05.11.22	<i>[Signature]</i> 05.11.23

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/11/18	4	one part scrap. wrong position in use.	<i>[Signature]</i> 05/11/22	Scrap, destroy No Replace.	<i>[Signature]</i> 05/11/18	<i>[Signature]</i> 05.11.23	<i>[Signature]</i> 05/11/22	<i>[Signature]</i> 05.11.23

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 05/11/23

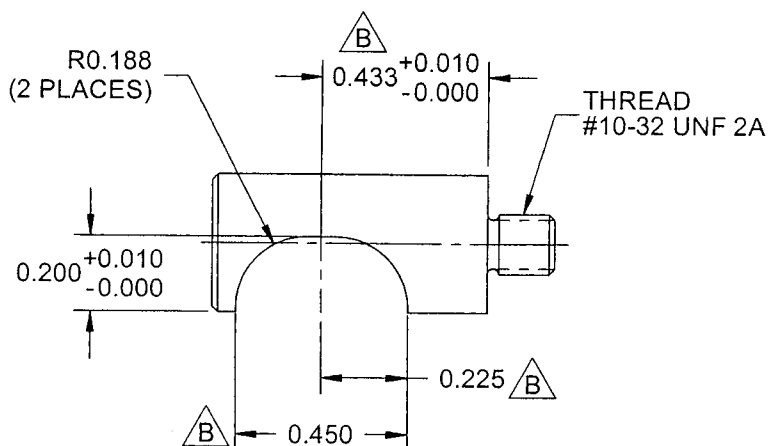
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 6 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

RELEASED  
*[Signature]*  
05/04/28



### D3372-5 CAM LOCK SHAFT

#### NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 22290

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DART AEROSPACE LTD		Work Order:	22290
Description: Cam Lock Shaft		Part Number:	D3372-5
Inspection Dwg: D3372	Rev: B	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<del>0.390</del>	<del>+0.010/-0.000</del>					
<del>0.200</del>	<del>+0.010/-0.000</del>					
<del>R0.188</del>	<del>+/-0.010</del>					
<del>0.290</del>	<del>+0.010/-0.000</del>					
<del>0.563</del>	<del>+/-0.010</del>					
<del>0.170</del>	<del>+/-0.010</del>					
<del>0.365</del>	<del>+/-0.010</del>	<del>0.375</del>	<del>X</del>			
1/4-20 Major dia	0.241 - 0.248					
<del>MOV</del>	<del>0.252 - 0.259</del>					
0.365	<del>+0.010</del> <del>-0.000</del>	0.370	✓			05.10.27 Permanent change.
0.900	<del>±0.030</del>	0.890	✓			
0.175	<del>±0.010</del>	0.176	✓			
<del>R0.015 X 0.035</del>						
R0.015 X 0.035	<del>±0.010</del>	R0.015 X 0.035	✓			
0.015 X 45°	<del>±0.010</del>	0.015 X 45°	✓			
<del>0.200</del>	<del>±0.010</del>					
0.450	<del>±0.010</del>	0.448	-			can measure (use d.m.c.r.)
0.200	<del>±0.010</del> <del>-0.000</del>	0.200	-			
0.433	<del>±0.010</del> <del>-0.000</del>	0.433	-			
R0.188	<del>±0.010</del>	0.188	-			
#10-32 UNF 2A	-	10-32 UNF 2A	✓			

Measured by: S.G.	Audited by: En	Prototype Approval:	N/A
Date: 05/10/27	Date: 05/11/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.05.26	New Issue	KJ/JLM	

RELEASED  
05/11/18

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jan 25, 2005  
03:20 pm

Work Order No : 0022290  
Project Name : D3372-5  
Project For : WK507  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3372-5  
Description : Cam Lock Shaft  
Manufactured : Yes  
Amount Req'd : 50  
Amount Done : 0  
Start Date : 01-25-05  
Est Finish Date : 02-15-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00